

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009070**Date Inspected:** 22-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin and Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as Bike Path cantilever 2 & 3 and OBG 4BE. The weld designations reviewed are as follows:

BK3

1. BK3-001-001~003

BK2

1. BK2-001-003~005, 007, 009, 068

2. BK2-001-054, 049

OBG 4BE

1. SSD18A-PP28-004

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This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector observed a rejectable indication at the time of testing. The QA Inspector generated a TL-6028 MT report on this date. Welds MT verified was identified as listed below:

BK2

1. BK2-001-006

This QA Inspector observed a indication in the above noted weld accepted by ZPMC QC MT personal. This QA Inspector issued an incident report on the above noted MT rejection.

1AAE & 1AE

FCAW welding of weld joints 111~118 located on OBE1.

Welder is identified as Mr. Yun Chuanshan (050316). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133 and WPS-B-T-2132.

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trial assembly yard. Locations are as followed:

1. Side plate on crossbeam (CB) side of segment 1AAW & 1AW at excavation areas. Locations of MT performed are measured off the CB edge at approximately 3380 and 3830mm.
2. Hold back welds on the various bottom plate stiffeners on 1AAE & 1AE.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

1. Setting up to move segment 4W to dock for placement on ship.
2. Worker removing indications (hand held grinder) at excavation areas on side plate (CB) at 1AAW&1AW.

Note:

Due to inclement weather, work was limited in the OBG Trail Assembly Yard on today's work shift.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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